

Work Order ID 98599

March-14-13 2:01:33 PM

\*98599\*

PRELIMINARY ISSUE

Page 1

Item ID: D3914-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 3/28/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *13-03-14* Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3914

pcl

D4020

A

100 Weld per dwg A/R S.S. rod Batch: *124816* 0.00

\*100\*

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

\*\*\*Visual inspect before welding mesh\*\*\*

3- tack weld mesh on basket as per dwg D3914

\*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Quality Control

Memo

0.00

*QC 13.3.28* *(1x)*

*13.03.28*

# Work Order ID 98599

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**\*98599\***

Page 2

Item ID: D3914-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 3/28/13 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start <b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop <b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
16

13/03/25

to PC1 Des only

130 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: 12:10

Oven Temperature: 320°F

Finish Time: 12:40

140 Wing Walk as per dwg QSI005 4.4 Batch 121376 0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label\*\*\*

1X m/ 13/04/01

1 φ B2/B4-2.

M123480

# Work Order ID 98599

**\*98599\***

Page 3

Item ID: D3914-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/28/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

1x 0 M 13/04/08

160

Identify as per dwg & Stock Location

D4784-041

98632

**\*160\***

Packaging

Memo

0.00

Packaging

1 0 BR 13-4-3

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE

13-03-14

AUTH

[Signature]

RELEASED

DATE

[Signature]

MF  
13-4-4

# Picklist Print

March-14-13 2:01:36 PM

Work Order ID: 98599

\*98599\*

Parent Item: D3914-041

\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/13

Required Date: 3/28/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC  
PER DWG REV.pc1 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	92.0000	2	2			

\*D2581\*

Mounting Bracket

\*\*

Pl 13.3.28  
397756 → (2)

Location	Loc Qty	Loc Code
WA	20	
96599	20	
WA004	72	
70766	2	
81253	1	
82506	2	
83230	3	
85452	2	
87706	2	
94204	16	
97756	24	
98108	20	

D3914-1

Manufactured No

100

Each

7.0000

2

2

\*D3914-1\*

Rib

\*\*

Pl 13.3.28  
388645 → (2)

Location	Loc Qty	Loc Code
WA004	4	
88645	4	
WA005	3	
81449	1	
82131	1	
87079	1	

# Picklist . . int

March-14-13 2:01:36 PM

Page 2

Work Order ID: 98599

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

\*98599\*

\*D3914-041\*

Start Date: 3/14/13

Required Date: 3/28/13

Start Qty: 1.00

Required Qty: 1.00

D3914-7 Manufactured No

100 Each 21.0000 2 2

\*D3914-7\*

Rib

\*\*

*P/L 13.3.28*  
B 97749 → (2)

## Location

## Loc Qty

## Loc Code

WA004

4

97135

4

WA005

17

82928

3

88649

1

97949

13

D4016-3 Manufactured No

100 Each 34.0000 3 3

\*D4016-3\*

Hinge Half, Lid

\*\*

*P/L 13.3.28*  
B 95317 → (3)

## Location

## Loc Qty

## Loc Code

WA004

34

94755

8

95317

8

95563

18

D4018-5 Manufactured No

100 Each 27.0000 9 9

\*D4018-5\*

Rib

\*\*

*P/L 13.3.28*  
B 88678 → (9)

## Location

## Loc Qty

## Loc Code

WA004

27

88678

27

D4020-5 Manufactured No

100 Each 4.0000 1 1

\*D4020-5\*

Mesh (350 Basket Long, Lid)

\*\*

*P/L 13.3.28*  
B 96661 → (1)

## Location

## Loc Qty

## Loc Code

WA007

4

96611

4

March-14-13 2:01:37 PM

Shop Packet Print

Page 2

# Picklist Print

March-14-13 2:01:37 PM

Page 3

Work Order ID: 98599

\*98599\*

Parent Item: D3914-041

\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/13

Required Date: 3/28/13

Start Qty: 1.00

Required Qty: 1.00

D4021-3 Manufactured No

100 Each 10.0000 1 1

\*D4021-3\*

Data Plate

\*\*

*Pl 13.3.28*  
*388510 → ①*

## Location

## Loc Qty

## Loc Code

WA004

10

80897

9

82507

1

D4035-041 Manufactured No

100 Each 7.0000 2 2

\*D4035-041\*

Lid Rib Assembly, Fwd (350 Basket)

\*\*

*Pl 13.3.28*  
*398598 → ②*

## Location

## Loc Qty

## Loc Code

WA004

6

97733

6

WA005

1

89282

1

D2728-3 Manufactured No

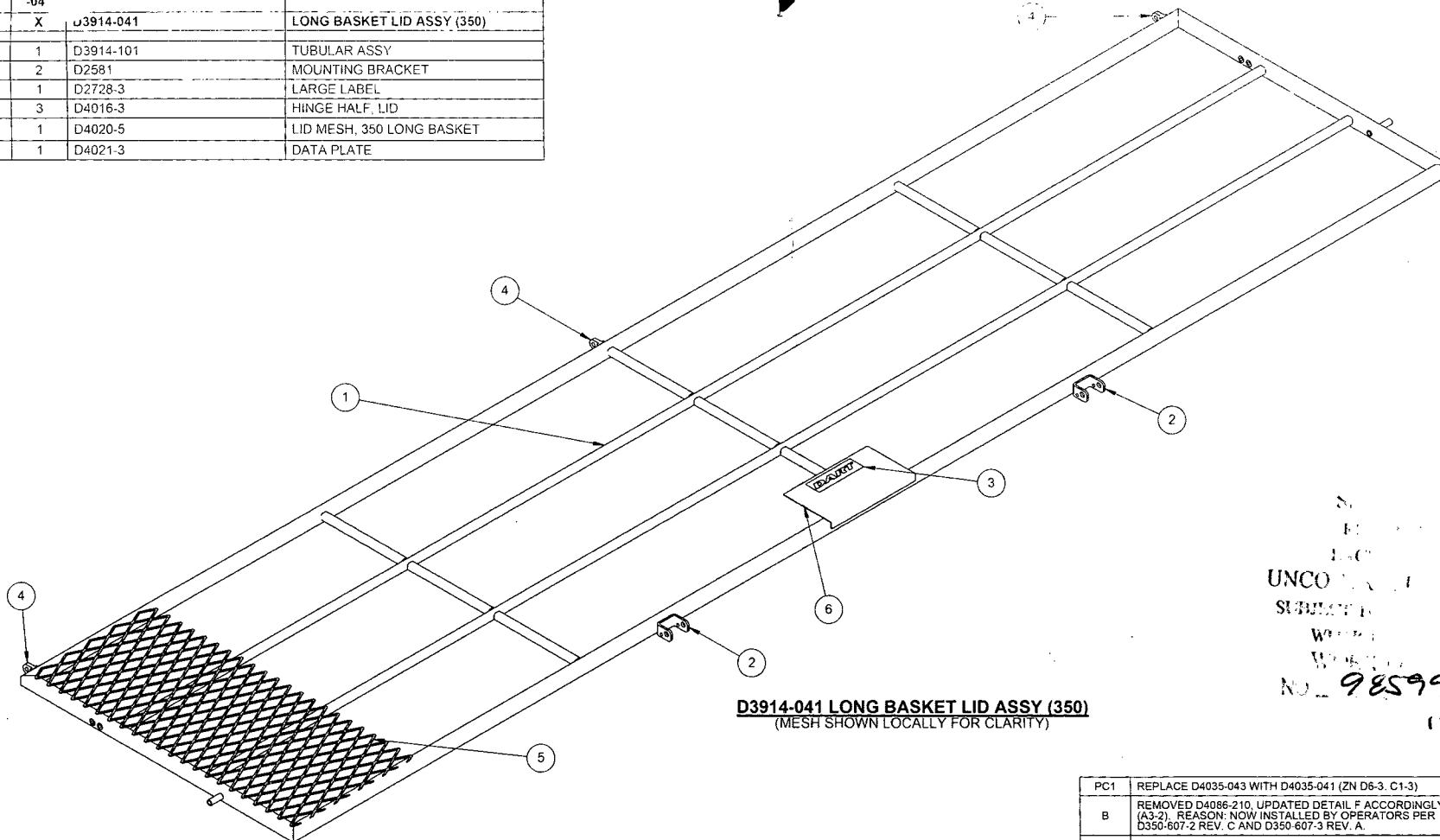
140 Each 0.0000 0 0

\*D2728-3\*

Dart Logo label

\*\*

ITEM	QT -04	PART NUMBER	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	LARGE LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE

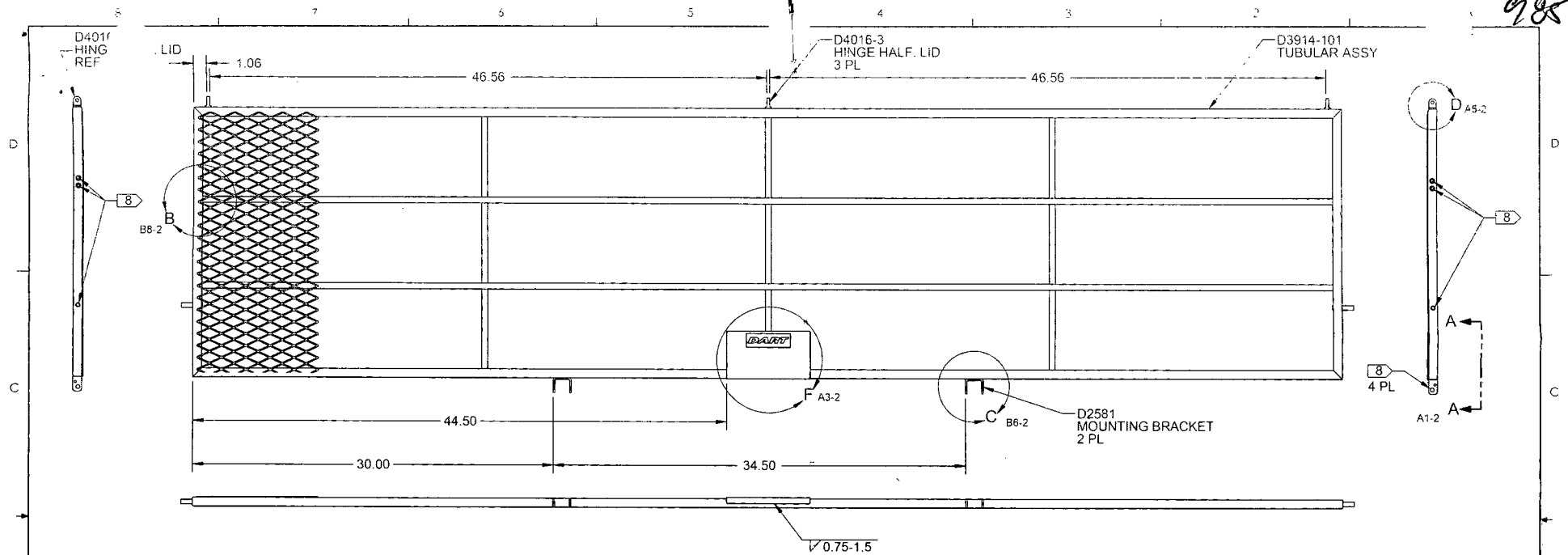


**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

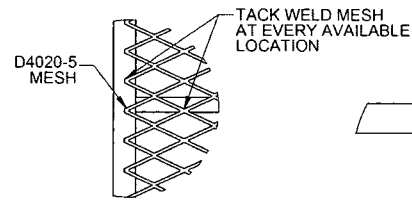
UNCO  
SUBMIT  
WORK  
WORK  
NO. 98599 MLJ  
13-03-14

PC1	REPLACE D4035-043 WITH D4035-041 (ZN D6-3, C1-3)	RF	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. PC1
MFG. APPR.		D3914	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	13.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

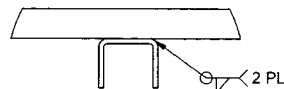
98599



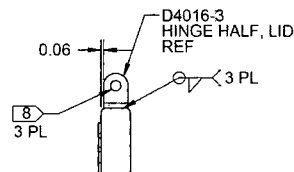
**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



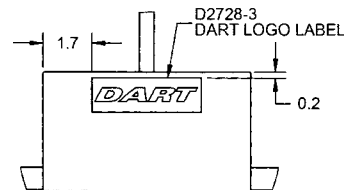
**DETAIL B** D8-2



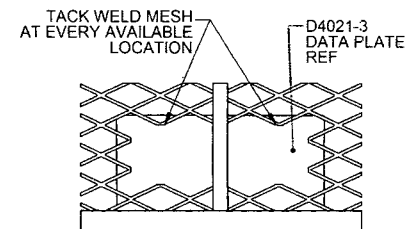
**DETAIL C** C3-2



**DETAIL D** D1-2



**DETAIL F** C4-2



**VIEW A-A** C1-2

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

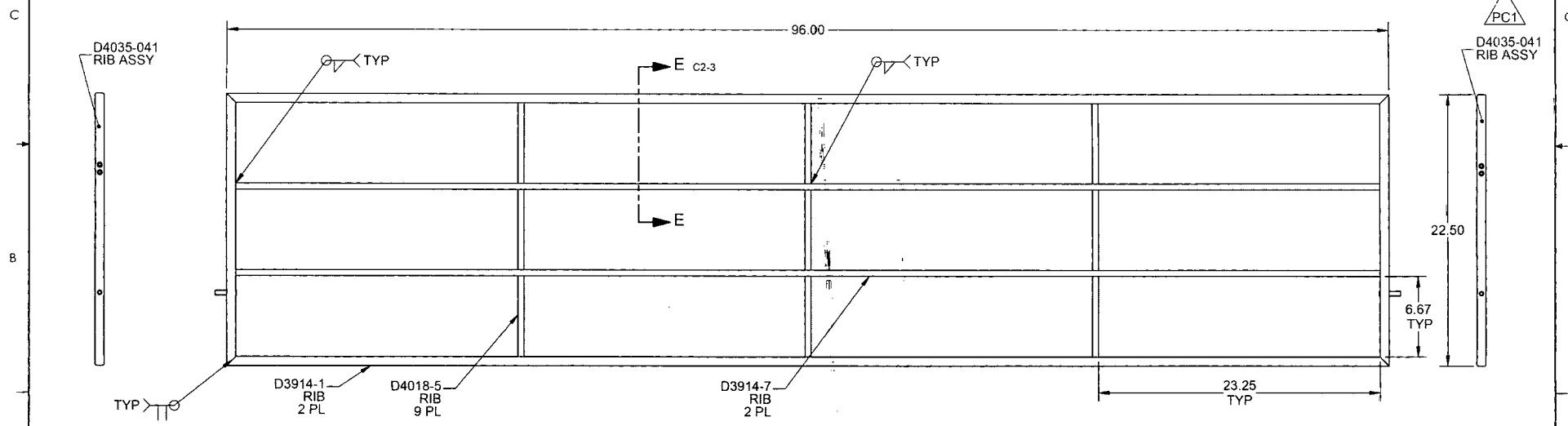
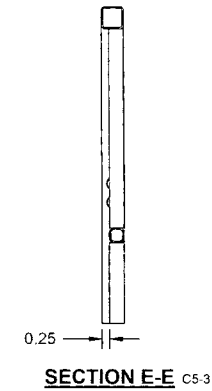
DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. PC1
MFG. APPR.		<b>D3914</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET LID ASSY (350)</b>	NTS
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98596

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D3914-101	TUBULAR ASSY. LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-041	BASKET LID RIB ASSY

PC1

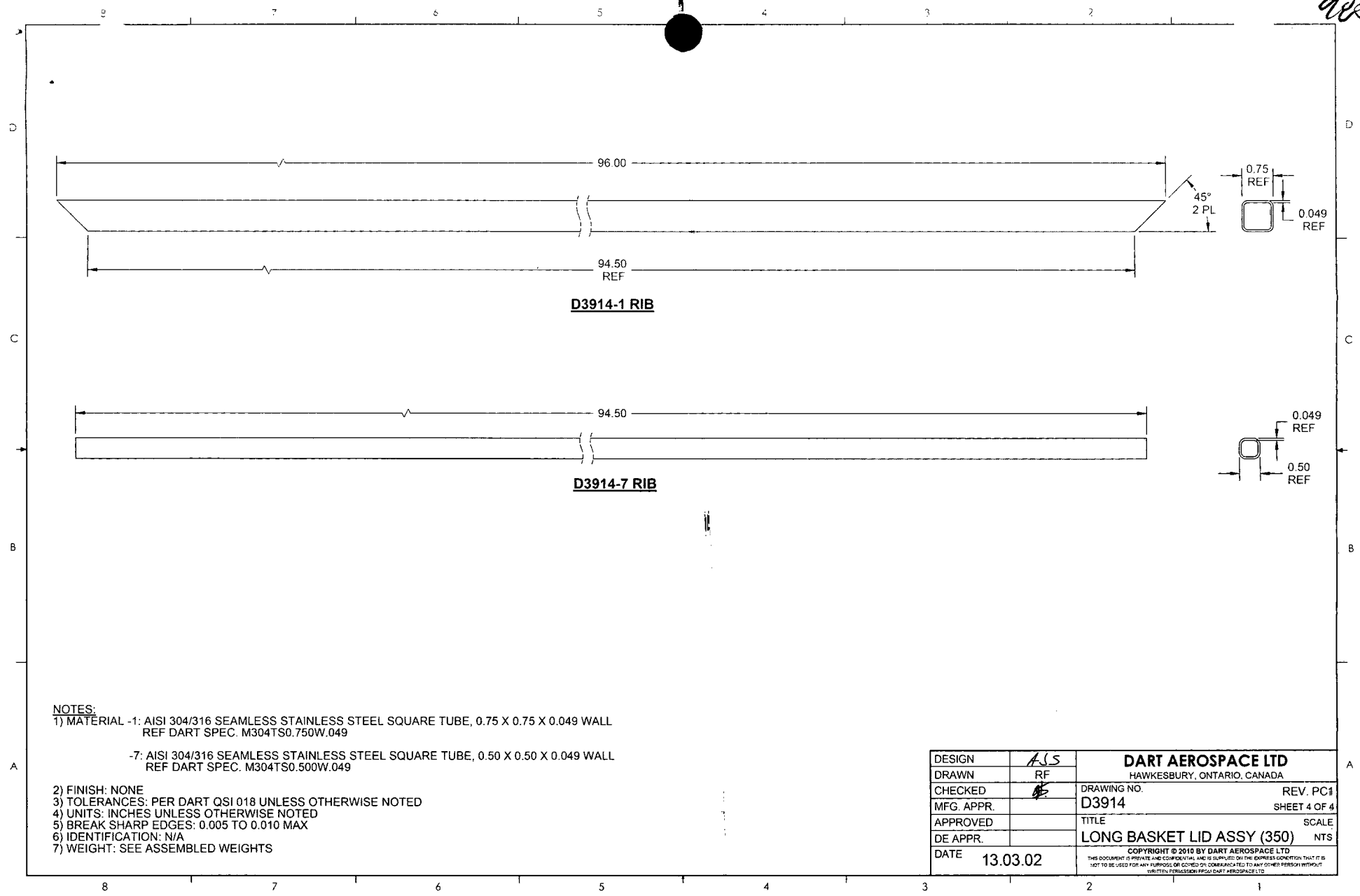


8 D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.15 lbs
  - 8) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. PC1
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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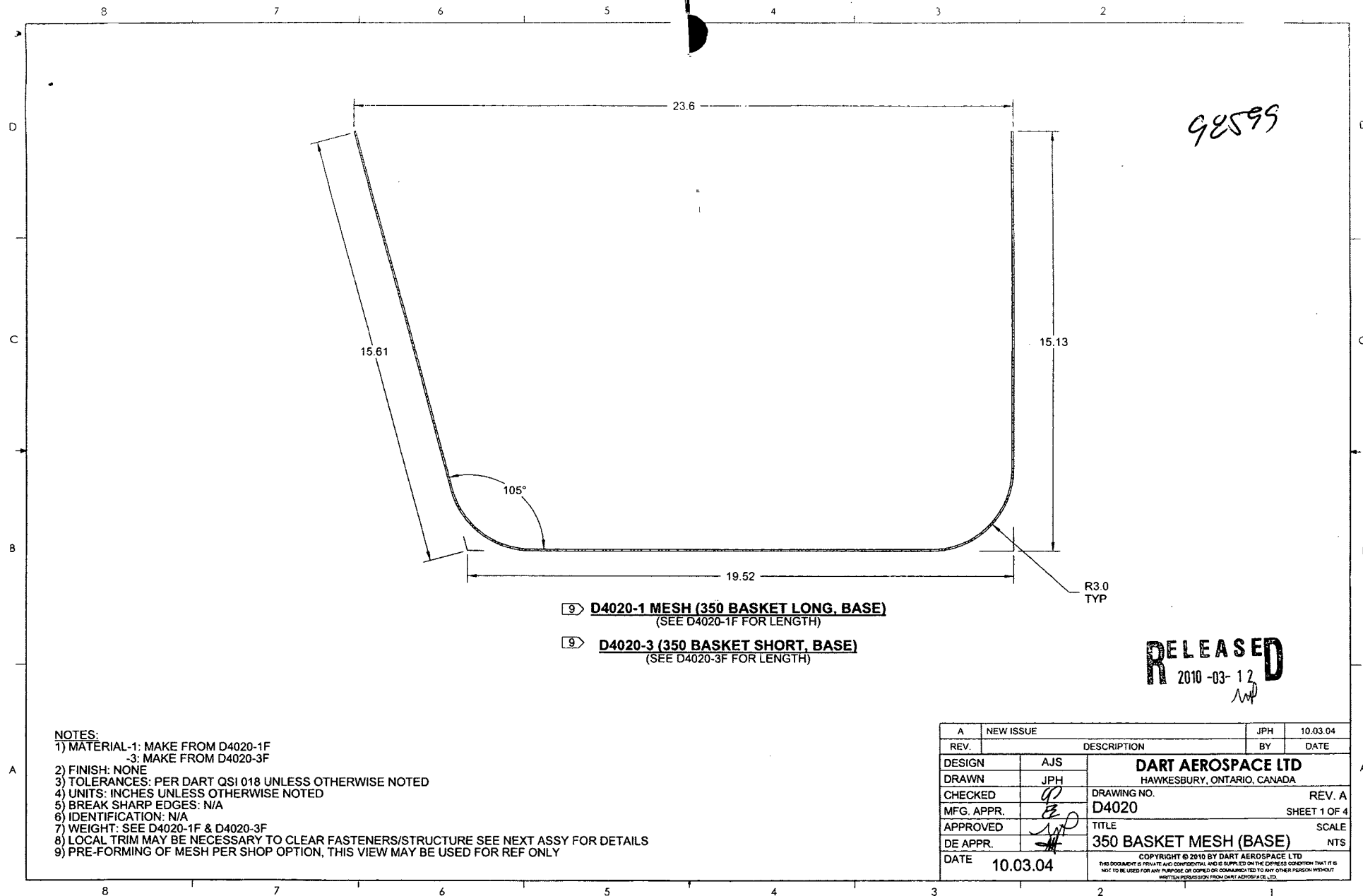
98559



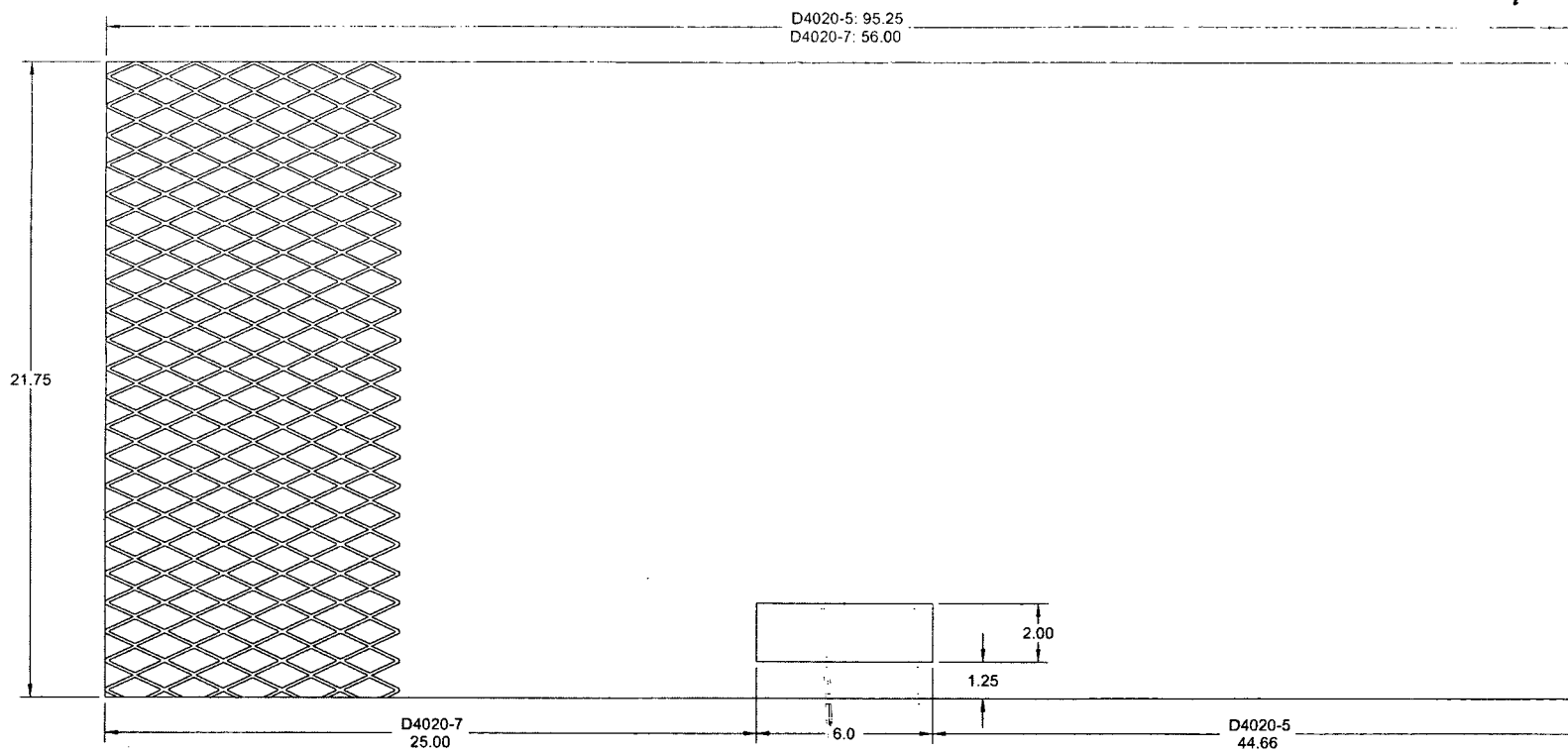
**NOTES:**

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AIS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. PC1
MFG. APPR.		D3914	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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92599



9) **D4020-5 MESH (350 BASKET LONG, LID)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9) **D4020-7 MESH (350 BASKET SHORT, LID)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

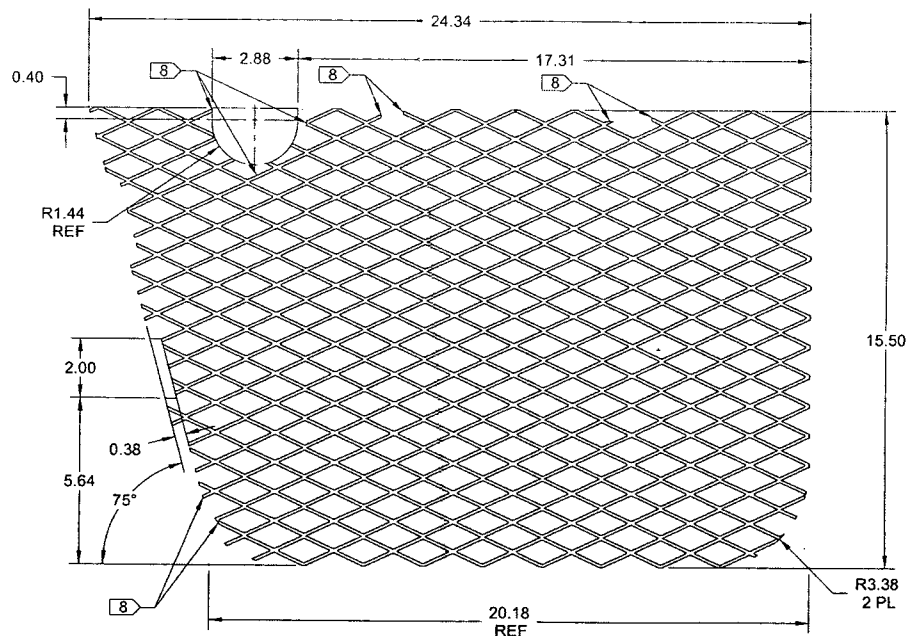
**NOTES:**

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX  
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

**RELEASED**  
2010-03-12

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4020</b>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 BASKET MESH (BASE)</b>	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

98599







9 D4020-11 END MESH, BASKET

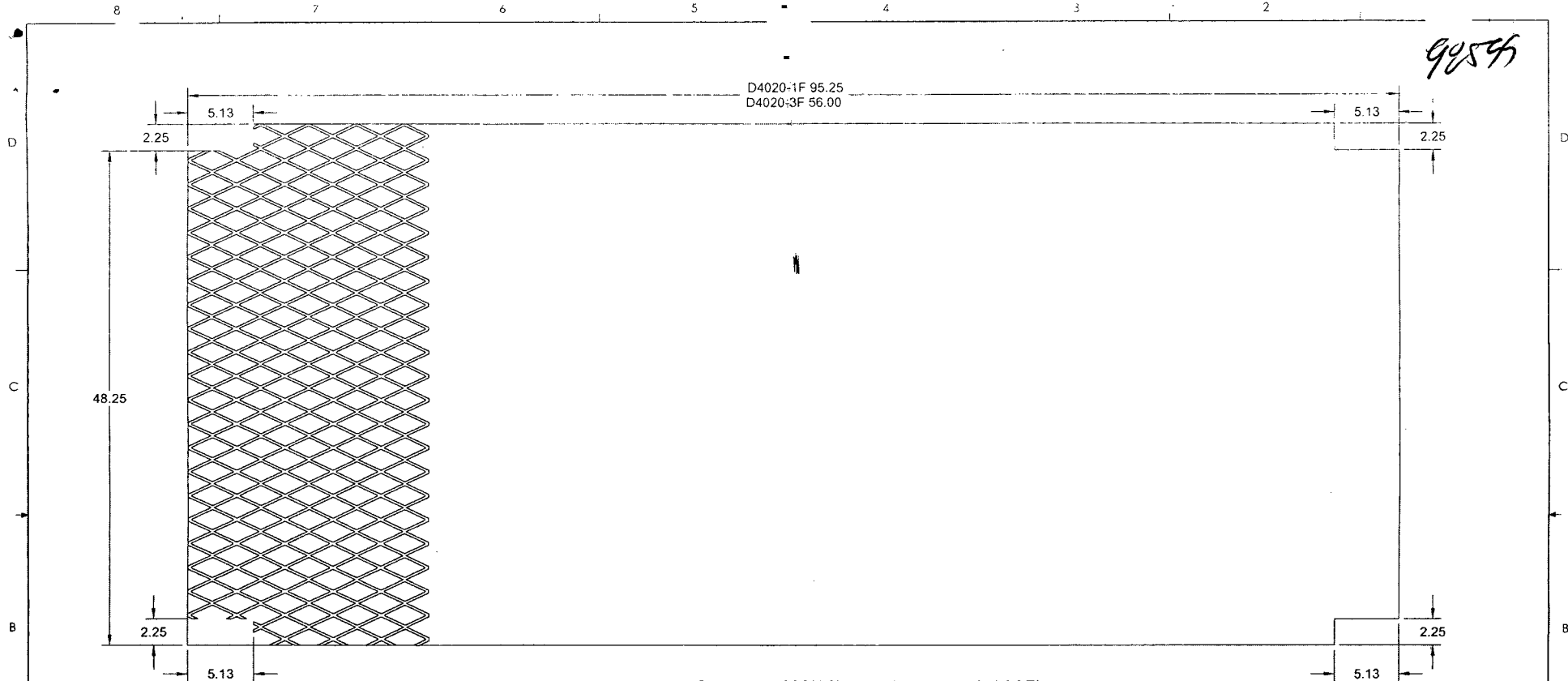
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

RELEASED  
2010-03-12

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4020	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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9454



8) **D4020-1F MESH (350 BASKET LONG BASE)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

8) **D4020-3F MESH (350 BASKET SHORT, BASE)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

**RELEASED**  
2010-03-13  
WJP

**NOTES:**

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 17.33 lbs APPROX  
-3F: 10.16 lbs APPROX
- 8) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4020</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 BASKET MESH (BASE)</b>	NTS
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